


Date: Thursday, 22/01/2009 7:57:26 AM  
 User: Melanie Fauteux

## Process Sheet

TULMAR

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOWER PAD ASSY	
Job Number	: 45030	Part Number	: PB674300135	
Estimate Number	: 13417	Drawing Number	: B6743001 P.40	
P.O. Number	:	Project Number	: N/A	
This Issue	: 22/01/2009 S.O. No. :	Drawing Revision	: B1	
Prsht Rev.	: NC	Material	:	
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 28/01/2009 Qty: 10 Um: Each	
Previous Run	: 41378			
Written By	:			
Checked & Approved By	: <u>mf 09-01-22</u>			
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.4402 sf(s)/Unit Total: 4.4016 sf(s)  
 2024-T3 .032 sheet  
 batch: 110778 B 9-2-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg B67-43001-341  
 Dwg Rev: B1  
 Prog Rev: B1 B 9-2-9  
 \*\*\*grain direction along 24.15" \*\*\*  
 2-Deburr if necessary B 9-2-9

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/02/10 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1- counter sink rivet holes as per dwg

S 09/02/11 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 22/01/2009 7:57:26 AM  
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# Process Sheet

TULMAR

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER PAD ASSY

Job Number: 45030

Part Number: PB674300135

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg B67-43001

SB 09/02/12 (12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/12 (12)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

99-02-12 (12)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316

START TIME: 9:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30am

99-02-13 (12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-02-13 (12)

11.0

MS20426AD34

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 140.0000 Each(s)

RIVET

batch: M104374 M1563

Ep 09/02/17 (17)

12.0

MS21075L3

Nutplate

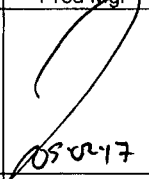
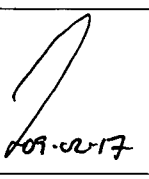


Comment: Qty.: 7.0000 Each(s)/Unit Total: 70.0000 Each(s)

Nutplate

batch: M110363

Ep 09/02/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-02-17	11-0	-4 rivets are too long for the ass'y. Need to use MS20426AD3-3. Perm change	SB	09/02/17	168	 09-02-17	 09-02-17	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:57:26 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER PAD ASSY

Job Number: 45030

Part Number: PB674300135

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Assemble as per dwg B67-43001

CP 09/02/17 (12)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/17 (12)

15.0

PG

PURCHASING



Comment: PURCHASING  
SEND TO TALMAR FOR FOAM AND FABRIC

R10: 8208 C 09/02/17 (10)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage

CP 09/03/17 (10)

17.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/03/05 (12)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

ST - 4307 UNF 09-03-05

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)  
D 09/03/06

Job Completion



UNF 09-03-05

POSITIVE RECALL

EFFECTIVE

AUTH

LEAD

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

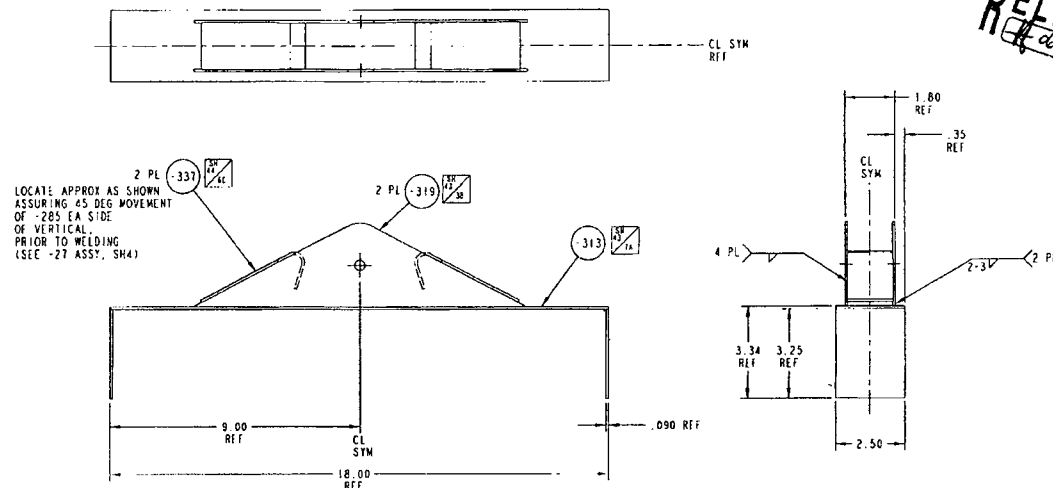
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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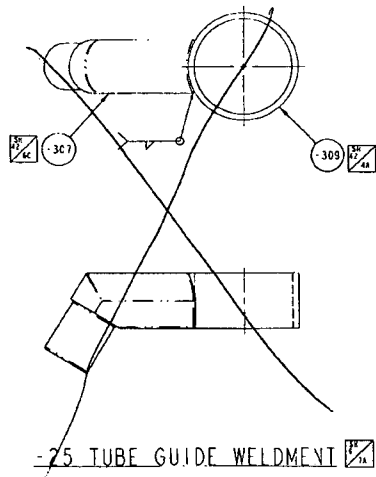
**NOTE:** Date & initial all entries



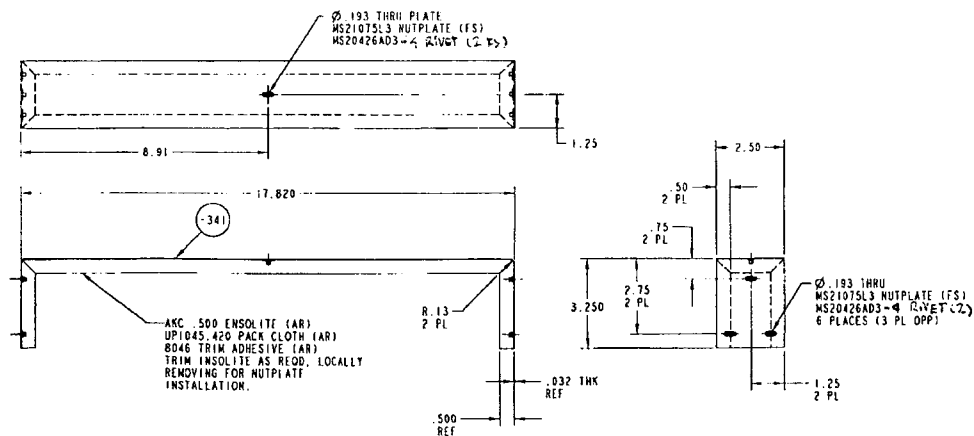
RELEASED  
# 66 11 20



① -29 BLADE POSITIONER WELDMENT  
SCALE 0.500



-25 TUBE GUIDE WELDMENT  
SCALE 1.000



① -35 LOWER PAD ASSY  
SCALE 0.500  
MATERIAL FOR -34, .032 THK 7024-13, 00-A-250/4

SUPERSEDED BY  
D3440-1 & D3440-3

PREMIER AVIATION, INC.  
2000 Aviation Parkway, Grand Prairie, Texas 75050  
D105UV8 B67-43001 181  
SCALE 1:1 SHEET 40 OF 45

ORIGINAL



# PACKING SLIP

# TULMAR

Tulmar Safety Systems Inc.  
1123 Cameron Street  
Hawkesbury, ON K6A 2B8 CA  
Tel: 613-632-1282  
Fax: 613-632-2030  
MID : XOTULSAF1123HAW  
email: info@tulmar.com

Bill No:

**Dart Aerospace**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

**31793**

Ship Date

4-Mar-09

*COPY*

Ship To:

**Dart Aerospace**  
1270 Aberdeen Street  
Att: Chantal Lavoie  
Tel: 613-632-9577  
Hawkesbury, ON K6A 1K7. Canada  
613-632-9577

Order number	Sales order date	Account number	Account manager
22839	18-Feb-09	CDART100	Barney Bangs
PO number	Ship Via	Pick-Up	PPD/COL
PO00008208			
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-109  
Dart Blade Fold Kit - Pad #10/  
Drawing No: (Ref B67-43001-35 Rev B1)  
DWG Rev:A  
Lot No: BATCH0000000005 Qty: 12

8421-106  
Dart Blade Fold Kit - Pad #7/  
Drawing No: (Ref B67-43001-69 Rev B1)  
DWG Rev:A  
Lot No: BATCH0000000004 Qty: 18

12

*Sold 03/05*

Shipper

*John Anderson*

Date:

**MAR 04 2009**

## Certificate of Conformance

☐ Not Applicable

I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.  
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Date: 03/04/2009

**RECEIVED**  
11-5-08



**CLIFTON**  
**Adhesive, Inc**  
**Industrial Adhesives & Coatings**

Date: 11/4/08

Shipper #: 11489

**Certificate of Compliance**

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,  
lot number (s) 08-294 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications  
which include quality control and assurance procedures. The material was  
manufactured on 10/20/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture  
Expiration Date: 10/20/09

This letter certifies that 5 x quart cans of CATUR Accelerator,  
Lot number 08-305 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications  
which include quality control and assurance procedures. The material was  
manufactured on 10/31/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture  
Expiration Date: 10/31/09

Sincerely,

*Dan Constantino*

Daniel Constantino  
Quality Assurance Mgr/ISO Coordinator

**Burgess Place • Wayne, NJ 07470 USA**  
**Phone: 973-694-0845 • Fax: 973-694-5678**  
**www.cliftonadhesive.com**

7122/24 (2)

AXED  
11-5-08



**CLIFTON**  
**Adhesive, Inc**  
**Industrial Adhesives & Coatings**

Date: 11/4/08

Shipper #: 11489

**Certificate of Compliance**

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manufactured on 10/20/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture  
Expiration Date: 10/20/09

This letter certifies that 5 x quart cans of CATUR Accelerator,  
Lot number 08-305 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications  
which include quality control and assurance procedures. The material was  
manufactured on 10/31/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture  
Expiration Date: 10/31/09

Sincerely,

*Dan Constantino*

Daniel Constantino  
Quality Assurance Mgr/ISO Coordinator

**Burgess Place • Wayne, NJ 07470 USA**  
**Phone: 973-694-0845 • Fax: 973-694-5678**  
**www.cliftonadhesive.com**

7122/24 (2)

frmGovernment

Page 1 of 2



American & Efid Inc.  
Post Office Box - 507  
Mount Holly, NC -28120

## Test Report

Date : 1/26/2009

QLL No. 844

Mfg. Date : 1/12/2009

Quantity: 16.9

Lot Id : 566518

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : VT295E TPII CLA F BT92N4

Customer Order Number : 15245-00

Plys (Visual) : 4

Customer : Tulmar Safety

Twist Direction : Z

Shipped To : Tulmar Safety

A&E Color : 63002 Black  
AA

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.3	14.8	15.3	15.3			
Strength #2 (Pound)	15	14.9	15	15.1	15.1			
Average Strength (Pound)						15.1	11.8	
Elongation #1 (Percent)	21.9	22.4	21.3	22.3	22.1			
Elongation #2 (Percent)	21.8	21.5	22.3	21.9	21.7			
Average Elongation (Percent)						21.9		26
Twist S #1 (Turns per inch)	12.3							
Twist S #2 (Turns per inch)	12.3							
Average Twist S (Turns per inch) Initial Twist						12.3		
Twist Z #1 (Turns per inch)	8.2							
Twist Z #2 (Turns per inch)	8.2							
Average Twist Z (Turns per inch) Final Twist						8.2	5.5	
Yield #1 (Yards/Pound)	4077.2							
Yield #2 (Yards/Pound)	4126.1							
Average Yield (Yards/Pound)						4101.6	3600	5200

Shade Evaluation : GOOD

Laundering : GOOD

Perspiration : GOOD

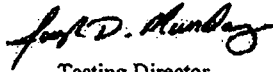
frmGovernment

Page 2 of 2

Wet Dry Cleaning :	<u>GOOD</u>
Light Test :	<u>GOOD</u>

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed :



Testing Director

**Note:**

This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in it's entirety.

E.F. Walter Inc.	<b><u>CERTIFICAT DE CONFORMITÉ</u></b> <b><u>CERTIFICATE OF COMPLIANCE</u></b>		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À  
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.  
1123 CAMERON STREET  
HAWKESBURY ONT  
K6A 2B8

Date : 07/15/2005

FOURNISSEUR  
VENDOR

E.F. WALTER INC.  
5000 HICKMORE  
ST. LAURENT, PQ  
H4T 1K6

Commande / Order # 10280

Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Piece # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72' (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72' (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé  
Signed

*[Signature]* July 15, 2005

EC #1637-001/01 (S)

E.F. Walter Inc.	<b>CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE</b>		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À  
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.

1123 CAMERON STREET

HAWKESBURY

ONT

K6A 2B8

Date : 09/09/2008

FOURNISSEUR  
VENDOR

E.F. WALTER INC.

180 BARTOR ROAD

TORONTO, ONTARIO

M9M 2W6

Commande / Order # 14649-00

Notre / Our Reference # 55968

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

Signé  
Signed

09/09/2008

TSC # 1637-001 / 02